

Date: Tuesday, 01/05/2007 2:18:53 PM
User: Linda Lacelle

Dart Aerospace Ltd.

Process Sheet

split 80 07/05/14

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 31867-2
Estimate Number : 12806
P.O. Number : *N/A*
This Issue : 01/05/2007
Prsht Rev. : NC
First Issue : *N/A*
Previous Run : 31867

Drawing Name : BRACKET

Part Number : D35702
Drawing Number : D3570 REV.B
Project Number : N/A
Drawing Revision : B
Material : *N/A*
Due Date : 13/05/2007

Qty: 60 Um: Ea

Written By :
Checked & Approved By :
Comment : Est Rev.A New Issue 07-03.26 ec

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M6061T6S125

6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total: 4.4730 sf(s)
6061-T6 .125 Sheet
Batch: *M103156*

Grain must be Along 4.63

2.0 WATER JET

FLOW WATER JET

SAD

07/05/04



Comment: FLOW WATER JET
1-Cut as per Dwg D3570
Dwg Rev: *B*
Prog Rev: *B*

2-Deburr if necessary

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/04

MF 07-05-07

60

(60)



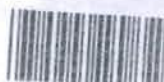
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK

SAD 07/05/04

60



Comment: SECOND CHECK

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

BE 07-05-04

60



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3570

FF 07-05-11

SB 07/05-11

60

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/14	5	Split up	SP	07/05/14	20	<i>[Signature]</i> 0705-15	<i>[Signature]</i> 0705-15

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 07/05/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31867

Part Number: D35702

Job Number:



Seq. #: Machine Or Operation: Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-05-15 (20)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 07-05-15 (20)

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

MS 07-05-15 (20)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ref 07/05/15 (20)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: *GA*

80 07/05/15 (20)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/16

Job Completion



U 07.05.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

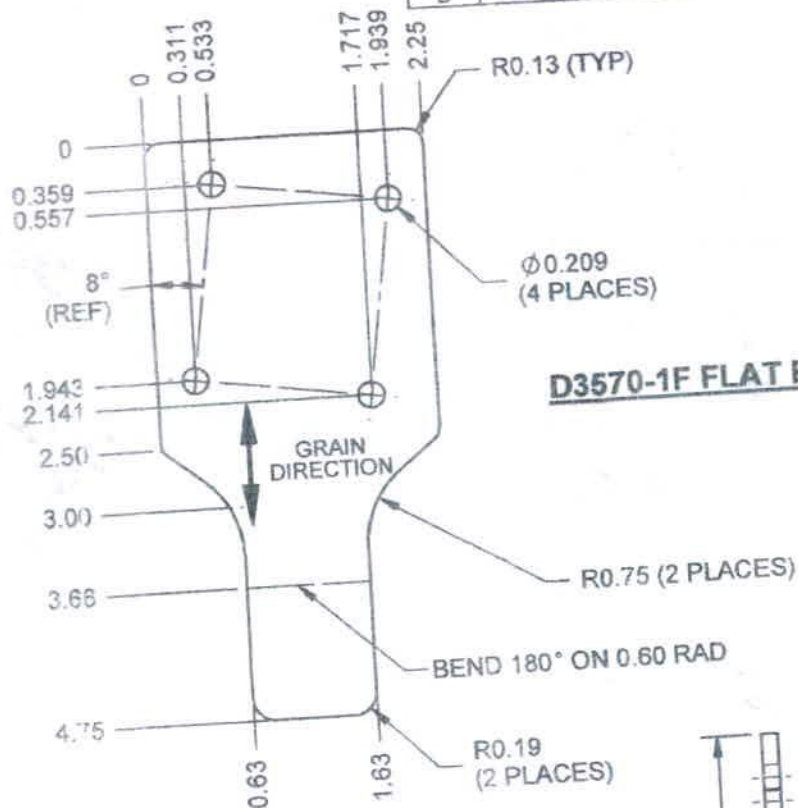
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>A</i>	DRAWING NO. D3570	REV. B SHEET 1 OF 1
DATE 07.04.16	TITLE BRACKET		SCALE 2:3
REV	DATE	DESCRIPTION	
A	07.02.07	NEW ISSUE	
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50	



RELEASED

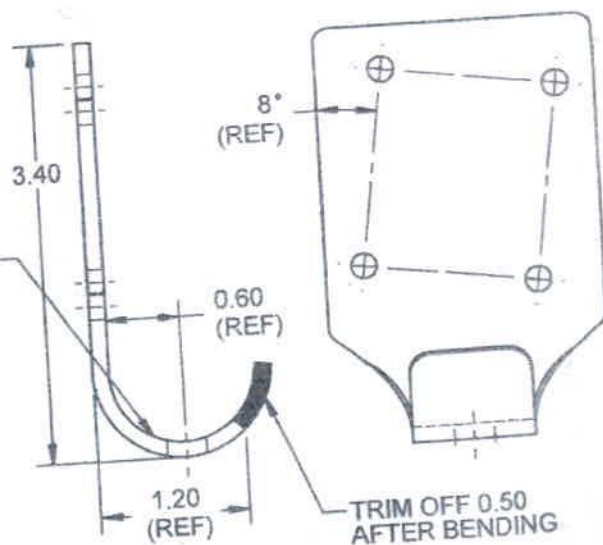
07.04.25

D3570-1F FLAT PATTERN

DRILL Ø0.328 AFTER BENDING
CENTERED ON PART & ON BEND

**D3570-1 BRACKET SHOWN
(MAKE FROM D3570-1F)**

**D3570-2 BRACKET OPPOSITE
(MAKE FROM D3570-1F)**



NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX




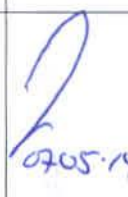
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-05-14	5.0	Parts/hole dimension of .600, below by .040 to .080". Parts not made as per drawing.	 QS1042	Rework parts to Dwg. See NCR 163.	SB 07/05/15	 07-05-15	 QS1042	 07-05-14

NOTE: Date & initial all entries

